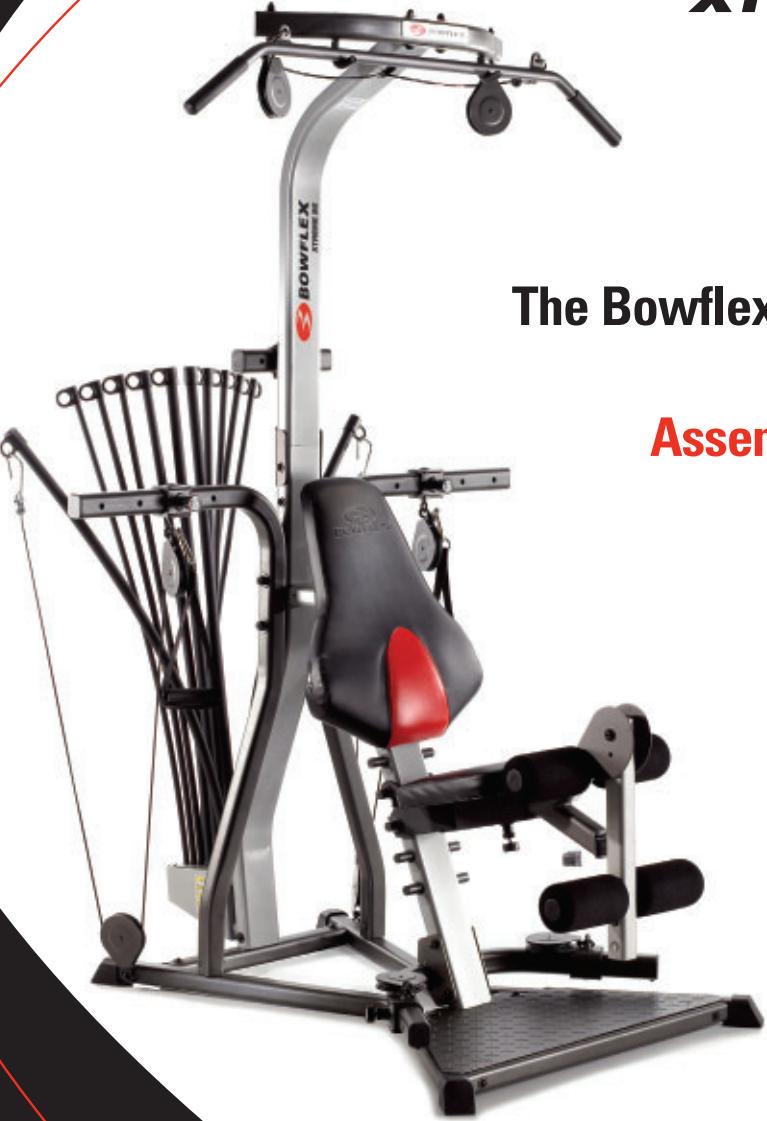




# BOWFLEX

## XTREME<sup>®</sup> SE



### The Bowflex Xtreme<sup>®</sup> SE Home Gym Assembly Manual







**Congratulations** on your commitment to fitness and your purchase of the Bowflex Xtreme® SE home gym. Before assembling your Bowflex Xtreme® SE home gym please read the Assembly Manual and follow the Important Safety Precautions. For information on how to use your Bowflex Xtreme® SE home gym refer to the Bowflex Xtreme® SE Owner's Manual.

Nautilus, Inc.  
16400 S.E. Nautilus Drive  
Vancouver, Washington, USA 98683

1-800-NAUTILUS (1-800-628-8458)  
Fax (800) 898-9410  
Nautilus.com  
Bowflex.com

---

## ***Table of Contents***

<b>Specifications / Approvals .....</b>	<b>1</b>
<b>Important Safety Precautions .....</b>	<b>2</b>
<b>Getting To Know Your Machine .....</b>	<b>3</b>
<b>Parts Reference Guide .....</b>	<b>4</b>
<b>Hardware Guide .....</b>	<b>7</b>
<b>Assembly Guide .....</b>	<b>8-18</b>
<b>Important Contact Numbers .....</b>	<b>19</b>



## Specifications / Approvals

---

### Product Specifications:

<b>Product Weight</b>	157 lbs. (71 kg)
<b>Product Dimensions</b>	53" (135 cm) long x 49" (124 cm) wide x 82" (208 cm) high
<b>Workout Area</b>	96" (244 cm) long x 78" (198 cm) wide
<b>Number of Exercises</b>	Over 60
<b>Power Rod® Resistance</b>	210 lbs. (95 kg)
<b>Power Rod® Upgradability</b>	310 lbs. (141 kg.) 410 lbs. (186 kg.)
<b>User Weight Limit</b>	300 lbs. (136 kg)

### Regulatory Approvals:



Meets:

EN957-1 Class H  
EN957-2 Class H



Meets:

ASTM F2276-05  
ASTM F2216-05





## Important Safety Precautions

### IMPORTANT SAFETY INSTRUCTIONS

The following definition applies to the word “WARNING” found throughout this manual:



**WARNING** Used to call attention to POTENTIAL hazards that could result in personal injury or loss of life.



**READ ALL INSTRUCTIONS  
BEFORE USING THE MACHINE.**



**WARNING**

**For your safety, perform all assembly steps in the sequence given. Improper assembly can lead to injury.**



**WARNING**

**Some components can be heavy or awkward to handle. Get help if necessary.**



# Getting to Know Your Machine

## Before You Assemble

Please take the time to read all assembly instructions before attempting to assemble your **Bowflex Xtreme® SE home gym**. Select where you are going to locate your machine carefully. The best place for your Bowflex Xtreme® SE home gym is on a hard, level surface.

Select a workout area that provides a minimum clearance behind the rod box of 0.5 ft (15 cm) and a total width of 6.5 ft (2.0 m). Allow a minimum of 3.0 ft (0.9 m) free space in front of the machine.

## Basic Assembly Principles

Here are a few basic tips that will make your assembly of the Bowflex Xtreme® SE home gym quick and easy. By using these principles, you can simplify each process and save yourself extra time and effort.

1. To make the assembly process go faster, gather the pieces you need for each step and thoroughly read the assembly instructions for that step prior to starting assembly for the step.
2. When tightening a locknut on a bolt, use a combination wrench to grip the locknut and ensure that it is fastened securely.
3. When attaching two pieces, gently lift and look through the bolt holes to help guide the bolt through the holes.
4. As a general rule, and for all bolts and nuts on your Bowflex Xtreme® SE home gym, turn bolts or nuts toward the right to tighten and left to loosen. Or you can remember the mnemonic: "Righty tighty, lefty loosey."

**IMPORTANT: LEAVE ALL CABLES COILED AND WRAPPED UNTIL YOUR  
BOWFLEX XTREME® SE HOME GYM IS FULLY ASSEMBLED.**



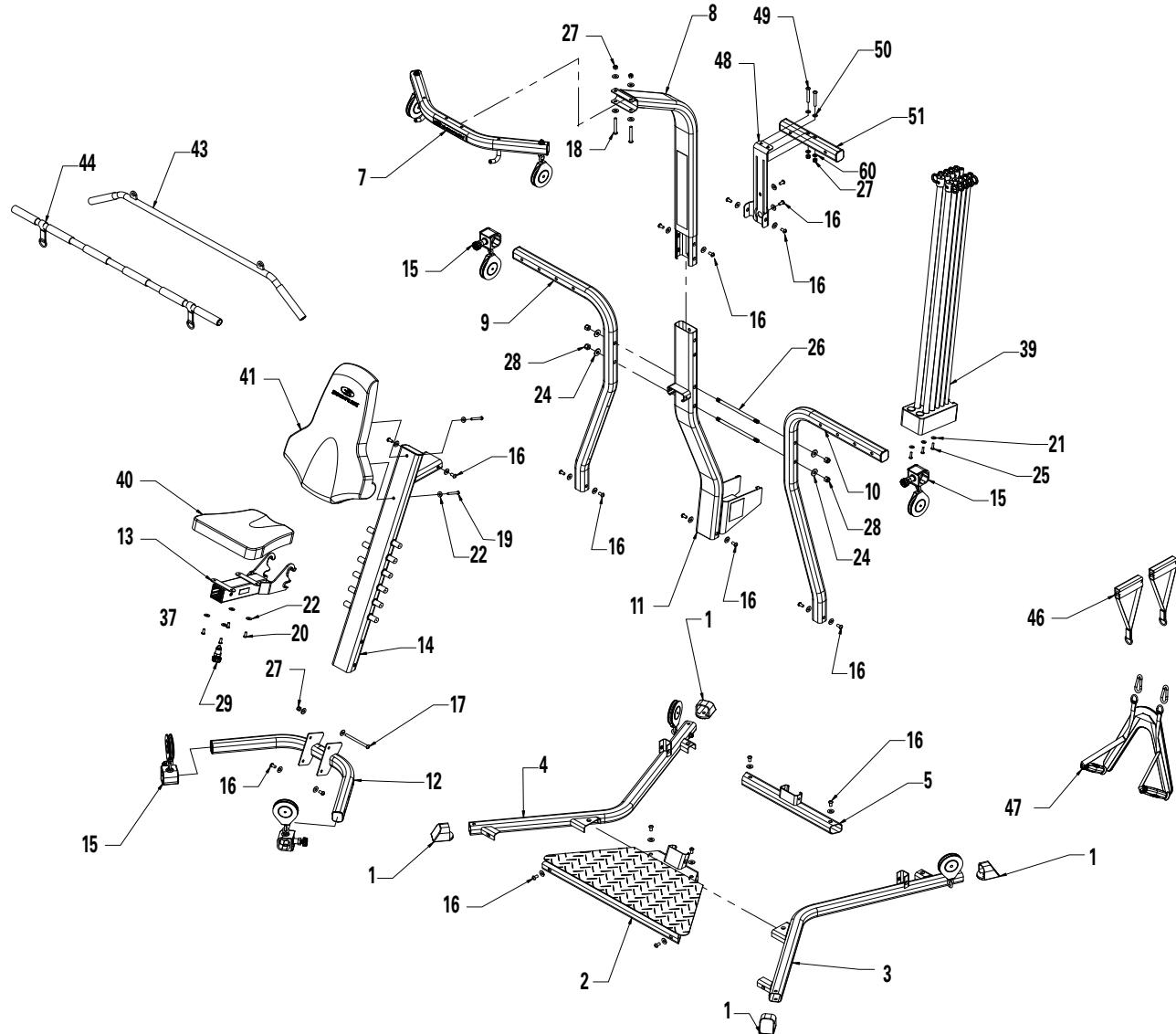


## Parts Reference Guide



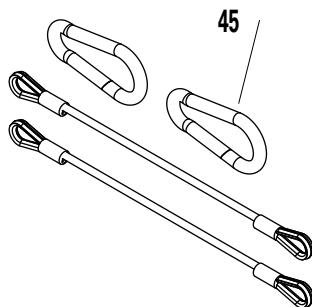
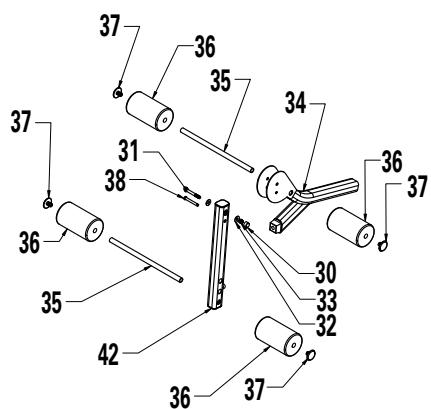
# BOWFLEX

## XTREME<sup>®</sup> SE



### Optional Leg Extension Attachment

If you ordered the optional Leg Extension Attachment, you will receive the additional parts shown here.





## Parts Reference Guide

ITEM	QTY.	DESCRIPTION	ITEM	QTY.	DESCRIPTION
1	4	FOOT, END CAP, FRAME	26	2	TS 0.500-13X9.5X.625X.750 BLK
2	1	BASE FRAME	27	5	LOCK NUT 0375-16 G2
3	1	RIGHT FRAME RAIL	28	4	LOCK NUT 0500-13 G2
4	1	LEFT FRAME RAIL	29	1	LOCK KNOB
5	1	REAR CROSMEMBER	30	1	CAP, BOLT COVER, PLASTIC
6	1	ABDOMINAL BRACKET	31	1	BUTTON HEAD CAP SCREW .375-16X3X1
7	1	LAT CROSS BAR W/ PULLEYS	32	2	FW-TYPE B-R 0.375-BLK
8	1	UPPER LAT TOWER	33	1	NUT, NYLOCK 3/8-16
9	1	RIGHT PULLEY ARM	34	1	LEG EXTENSION BACKBONE ASSEMBLY
10	1	LEFT PULLEY ARM	35	2	CHROME TUBE, FOAM ROLLER
11	1	LOWER LAT TOWER FRAME	36	4	FOAM ROLLER
12	1	SQUAT PULLEY FRAME	37	4	END CAP, 3/4 INCH
13	1	SEAT BACKBONE	38	1	PIN, BALL DENTENT, LEG EXT
14	1	SEAT SUPPORT RAIL	39	1	BOWFLEX ROD PACK 210#
15	4	PULLEY SLIDER	40	1	XTREME SE SEAT ASSEMBLY
16	22	BUTTON HEAD CAP SCREW 0375-16X0.75 G2	41	1	XTREME SE SEAT BACK ASSEMBLY
17	1	BUTTON HEAD CAP SCREW 0375-16X5 G2	42	1	LEG EXTENSION ASSEMBLY PIVOT TUBE
18	2	BUTTON HEAD CAP SCREW 0375-16X3 G2	43	1	BAR 50" BENT LAT BAR
19	2	BUTTON HEAD CAP SCREW 03125-18X2.5 G2	44	1	BAR 48" LONG WITH FOAM GRIPS
20	4	BUTTON HEAD CAP SCREW 03125-18X0.75 G2	45	1	ACC BAG LEG #1 ASSEMBLY
21	3	FLAT WASHER 0250	46	1	PVC HANDGRIP PAIR ASSEMBLY
22	6	FLAT WASHER 0313	47	1	AB CRUNCH STRAP ASSEMBLY
23	32	FLAT WASHER 0375	48	1	BRKT, AB CRUNCH
24	4	FLAT WASHER 0500	49	2	BUTTON HEAD CAP SCREW .0375-16X2.75 G2-BLK
25	3	PHILLIPS SCREW 0250-20X1	50	4	FLAT WASHER 0375 NARROW
			51	1	XTREME SE AB BRKT TUBE ASSY



## Parts Reference Guide

Base Frame	Left Frame Rail  Cable Pulley Slider and Cable are included with frame rail pulley. 	Right Frame Rail  Cable Pulley Slider and Cable are included with frame rail pulley. 	Rear Cross Member		
Lower Lat Tower Frame	Rod Box w/ Rods	Seat Support Rail	Squat Pulley Frame	Right and Left Pulley Arms	Abdominal Bracket
Seat Backbone	Seat Back	Upper Lat Tower	Lat Cross Bar with Pulleys  One cable is wrapped in each pulley bundle. 	2 Hand Grips	
50" Bent Lat Bar	Squat Bar	2 Squat Straps	8 Snap Hooks	Abdominal Crunch Shoulder Harness	Tools Included: 2 Allen Wrenches 

NOTE: Specifications Subject to Change Without Notice

## Optional Leg Extension Parts

Lock Knob	Leg Extension Backbone	2 Chrome Tubes (3/4")	4 Foam Rollers	4 End Caps (3/4")	2 Snap Hooks & 2 Cables

NOTE: Specifications Subject to Change Without Notice



# Hardware Guide

## Tools you will need:

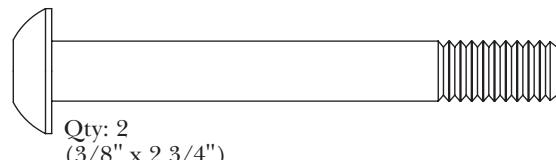
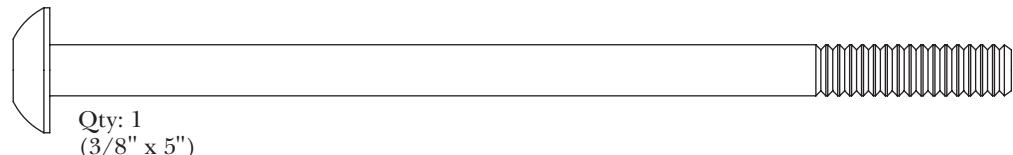
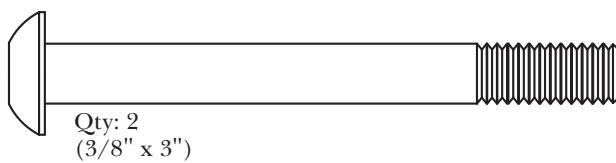
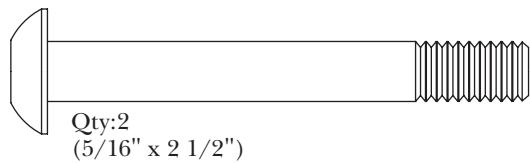
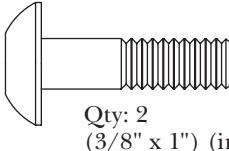
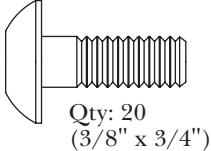
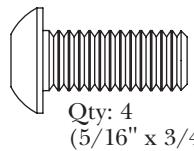
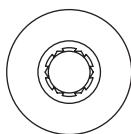
You will need the tools listed below to complete the assembly of your Bowflex Xtreme® SE home gym. If you don't have these tools, you can find them at any hardware or department store.

- 7/16" Combination Wrench
- 9/16" Combination Wrench
- Adjustable Wrench
- Socket Wrench Set
- Phillips Screw Driver

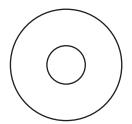
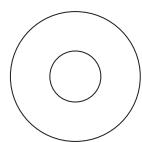
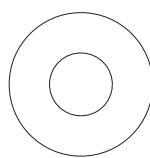
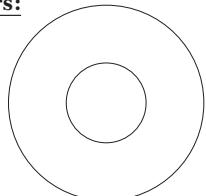
- Flat Blade Screw Driver
- Rubber Mallet
- Utility Knife
- Scissors
- Allen wrenches (included)

(NOTE: Drawings not to scale.)

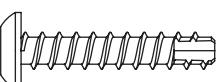
### Button Head Screws:



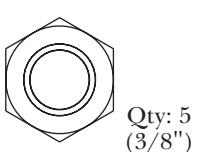
### Flat Washers:



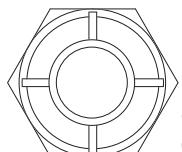
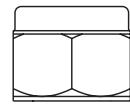
### Self Threading Screw:



Qty: 3  
Self Threading Screws (#10 x 1")



### Nylock Nuts:



Qty: 2 Threaded Studs  
(1/2" x 9 1/2")





# Assembly Guide

## Step 1 Base Frame Assembly

### Parts:

- Base Frame
- Left Frame Rail
- Right Frame Rail
- Rear Cross Member

### Hardware:

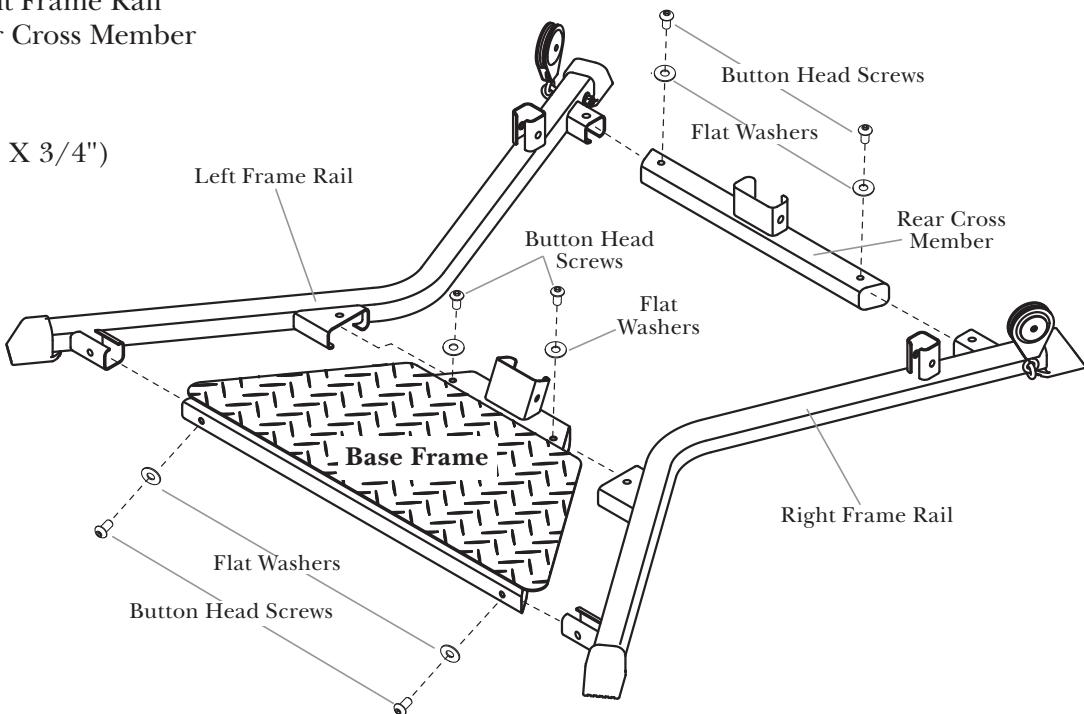
- 6 Button Head Screws ( 3/8" X 3/4")
- 6 Flat Washers (3/8")

**Tool:** 7/32" Allen Wrench  
(or Hex Wrench)

**1-1** Lay all parts on floor as shown.

**1-2** Insert Frame Rail connectors into the Base Frame and Rear Cross Member. Secure with screws and washers as shown.

**Finger tighten screws at this time.**



## Step 2 Lower Lat Tower Assembly

### Parts:

- Lower Lat Tower Frame
- Rod Box with Power Rod® Pack

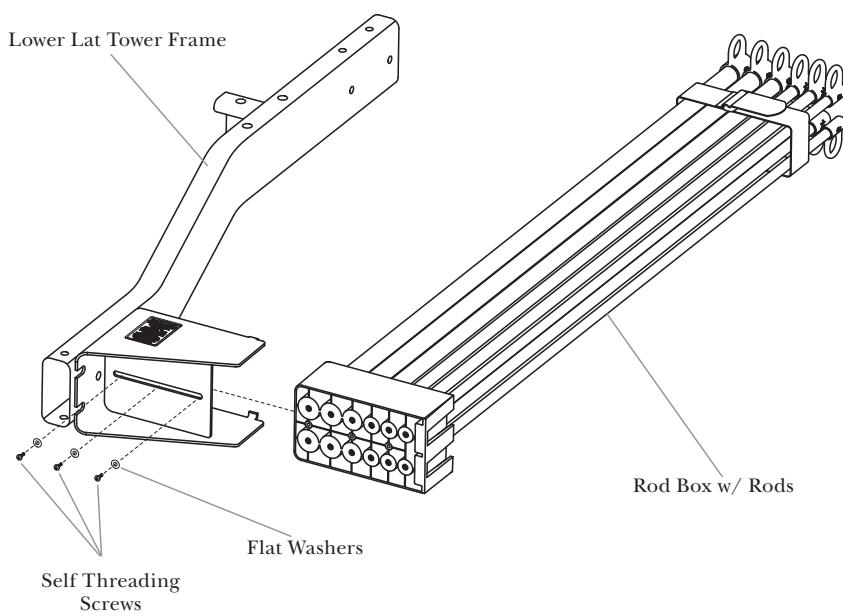
### Hardware:

- 3 Self Threading Screws (#10 X 1")
- 3 Flat Washers (1/4")

**Tool:** Phillips Screw Driver

**2-1** Lay parts on floor as shown. Firmly slide Rod Box into Lower Lat Tower Frame.

**2-2** Fasten the Rod Box to the Lower Lat Tower Frame with screws and washers as shown. Tighten screws until snug.





# Assembly Guide

## Step 3 Install Lower Lat Tower Assembly

### Parts:

- Lower Lat Tower Assembly
- Base Frame Assembly

### Hardware:

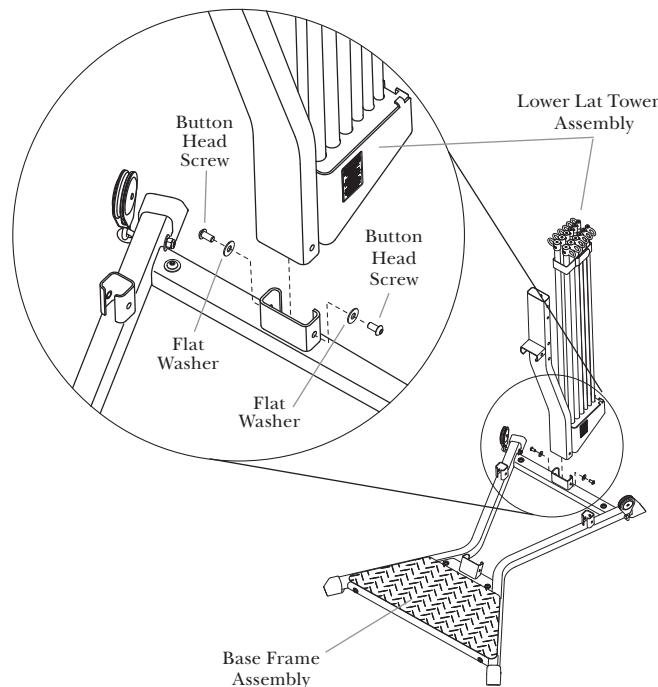
- 2 Button Head Screws (3/8" X 3/4")
- 2 Flat Washers (3/8")

**Tool:** 7/32" Hex Wrench

**3-1** Align the Lower Lat Tower Assembly over the Base Frame. Push the bottom of the Lower Lat Tower onto the connector of the Rear Cross Member as shown.

**3-2** Secure Lower Lat Tower Assembly using screws and washers as shown.

**Finger tighten screws at this time.**



## Step 4 Install Seat Support Rail

### Parts:

- Seat Support Rail
- Base Frame Assembly

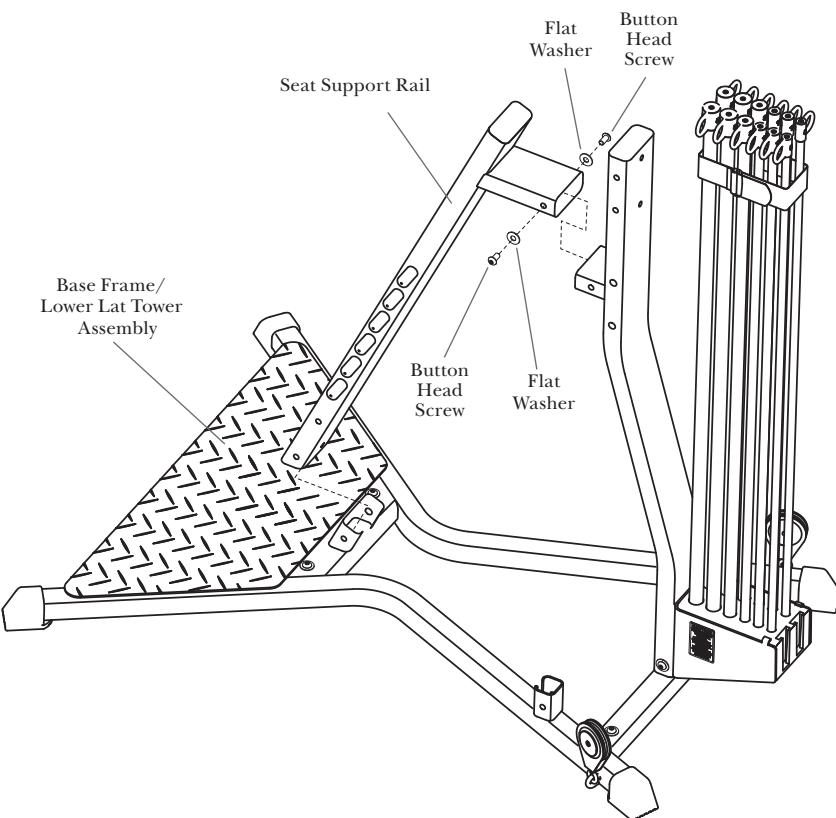
### Hardware:

- 2 Button Head Screws (3/8" X 3/4")
- 2 Flat Washers (3/8")

**Tool:** 7/32" Hex Wrench

**4-1** Slide the bottom of the Seat Support Rail onto the Base Frame connector as shown.

**4-2** Slide the top of the Seat Support Rail onto the Lower Lat Tower Assembly connector as shown. Secure using screws and washers as shown.



**Finger tighten screws at this time.**



# Assembly Guide

## Step 5 Install Squat Pulley Frame

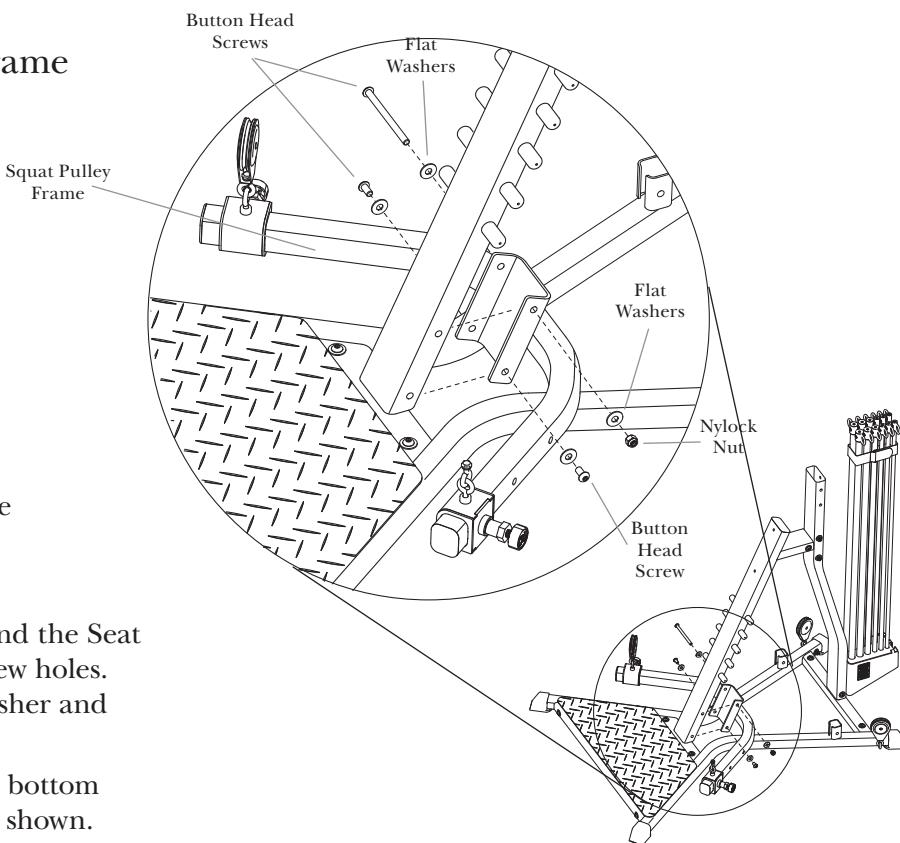
### Parts:

- Squat Pulley Frame Assembly
- Main Assembly

### Hardware:

- 1 Button Head Screw (3/8" X 5")
- 1 Nylock Nut (3/8")
- 2 Button Head Screws (3/8" X 1")
- 4 Washers (3/8")

**Tools:** 7/32" Hex Wrench & Adjustable or Socket Wrench



**5-1** Place the Squat Pulley Frame behind the Seat Support Rail and align the top screw holes. Secure using a 3/8" X 5" screw, washer and nut in the top hole as shown.

**5-2** Install screws and washers into the bottom holes of the Squat Pulley Frame as shown.

## Step 6 Install Pulley Arms

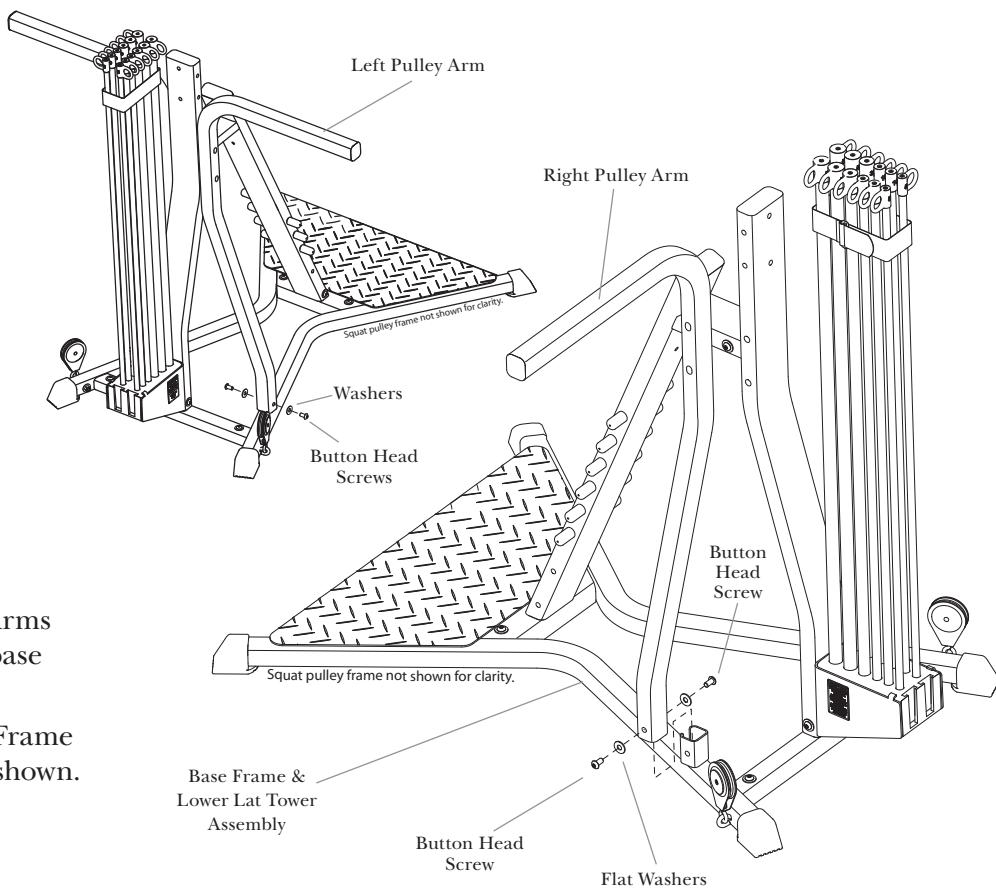
### Parts:

- Right Pulley Arm
- Left Pulley Arm
- Main Assembly

### Hardware:

- 4 Washers (3/8")
- 4 Button Head Screws (3/8" X 3/4")

**Tools:** 7/32" Hex Wrench



**6-1** Slide Left and Right Pulley Arms onto the connectors on the base frame as shown.

**6-2** Secure Pulley Arms to Base Frame using screws and washers as shown.

**Finger tighten screws at this time.**



# Assembly Guide

## Step 7 Secure Pulley Arms

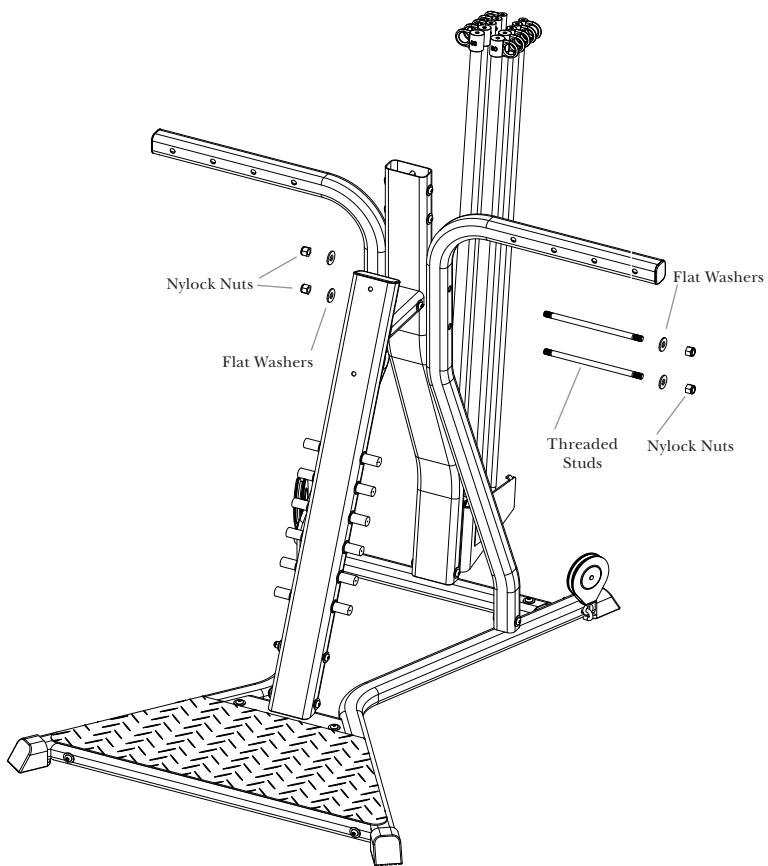
### Hardware:

- 2 Threaded Studs (1/2" X 9 1/2")
- 4 Nylock Nuts (1/2")
- 4 Washers (1/2")

### Tool:

Rubber Mallet

- 7-1** Align the two holes in the Pulley Arms with those in the Lower Lat Tower Assembly and secure using threaded studs, washers and nuts as shown.



## Step 8 Install Slider Pulleys

### Parts:

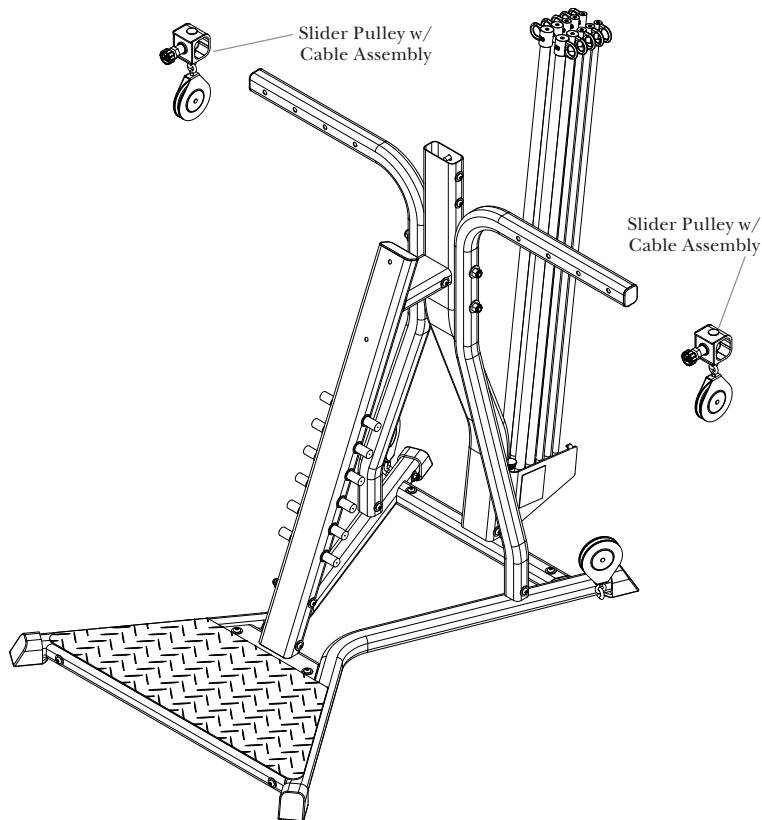
- 2 Slider Pulleys with Cable Assembly
- Main Assembly

### Tools:

3/16 Hex Wrench

- 8-1** Install a Slider Pulley onto each Pulley Arm as shown.

- 8-2** Choose any of the four holes to secure.





# Assembly Guide

## Step 9 Seat Assembly

### Parts:

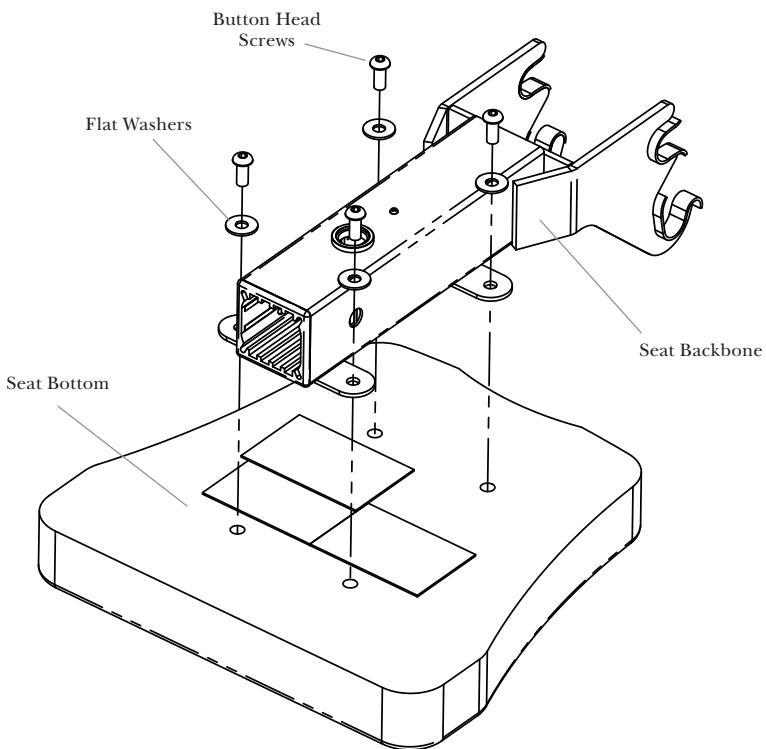
- Seat Backbone
- Seat Bottom

### Hardware:

- 4 Button Head Screws (5/16" X 3/4")
- 4 Washers (5/16")

**Tool:** 3/16" Hex Wrench

- 9-1** Install the Seat Backbone to the underside of the Seat Pad using screws and washers as shown.



## Step 10 Leg Extension Assembly

### Parts:

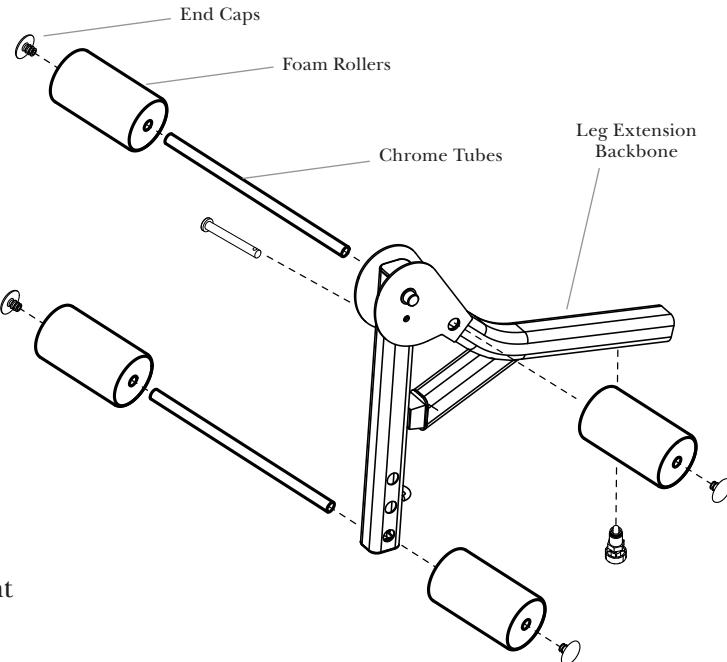
- Leg Extension Backbone
- 2 Chrome Tubes
- 4 Foam Rollers
- 4 End Caps

**Tool:** Rubber Mallet

- 10-1** Insert Chrome Tubes through the upper hole and one of the lower holes in the Leg Extension. (Select hole for your comfort level.)

- 10-2** Slide Foam Rollers onto the Chrome Tubes and secure with end caps. A rubber mallet may be needed to secure the end caps.

**NOTE:** The Leg Extension may be adjusted during workout to best suit your height and personal preferences.





# Assembly Guide

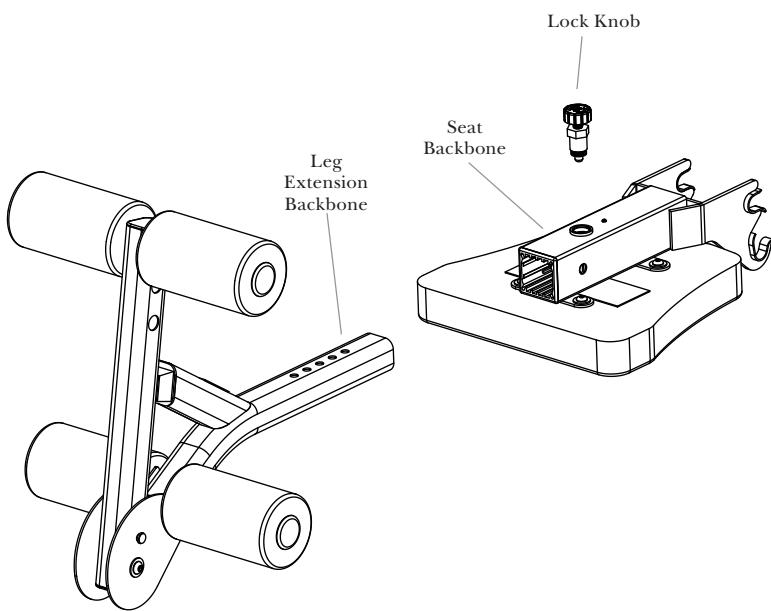
## Step 11 Install Optional Leg Extension Assembly

### Parts:

- Leg Extension Assembly
- Lock Knob

**11-1** Insert Leg Extension Backbone into open end of Seat Backbone as shown.

**11-2** Align one hole of the Leg Extension with the hole in the Seat Backbone to fit your height and secure with the Lock Knob as shown.



## Step 12 Install Seat Assembly

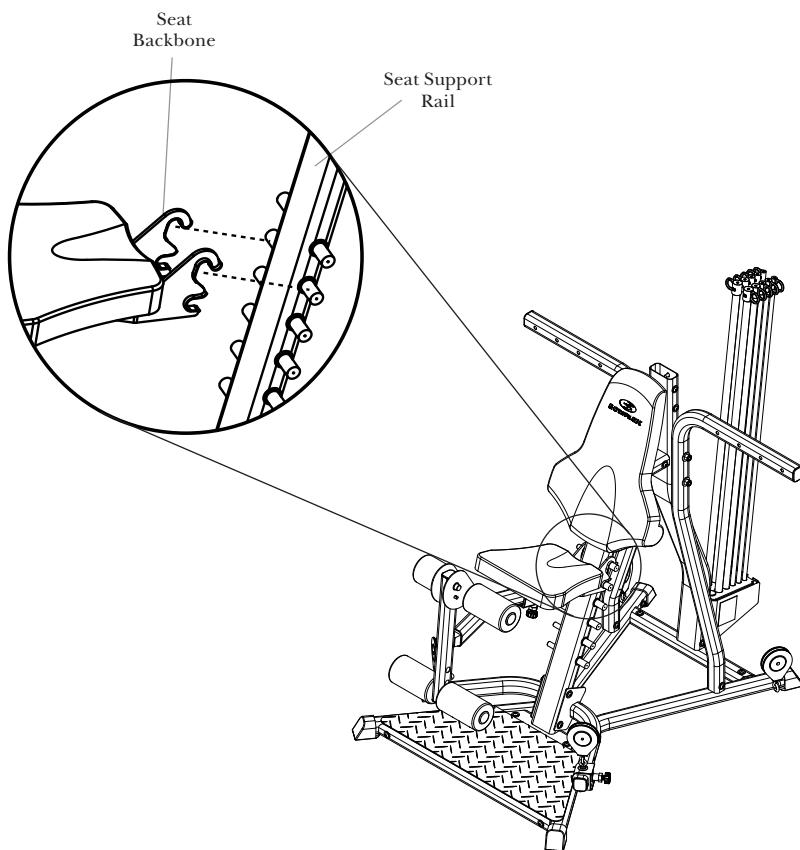
### Parts:

- Seat Assembly
- Main Assembly

**12-1** Align the top two hooks on the Seat Backbone with one of the lower pairs of pins on the Seat Support Rail.

**12-2** Tip seat front up and slide hooks onto pins. Rotate seat down and back to use.

**Note:** Use lower pins until the seat back is installed. Reverse procedure to remove seat.





# Assembly Guide

## Step 13 Install Seat Back Pad

**Note:** The back of the Seat Back Pad has two pairs of holes. Select the appropriate set based on your height.

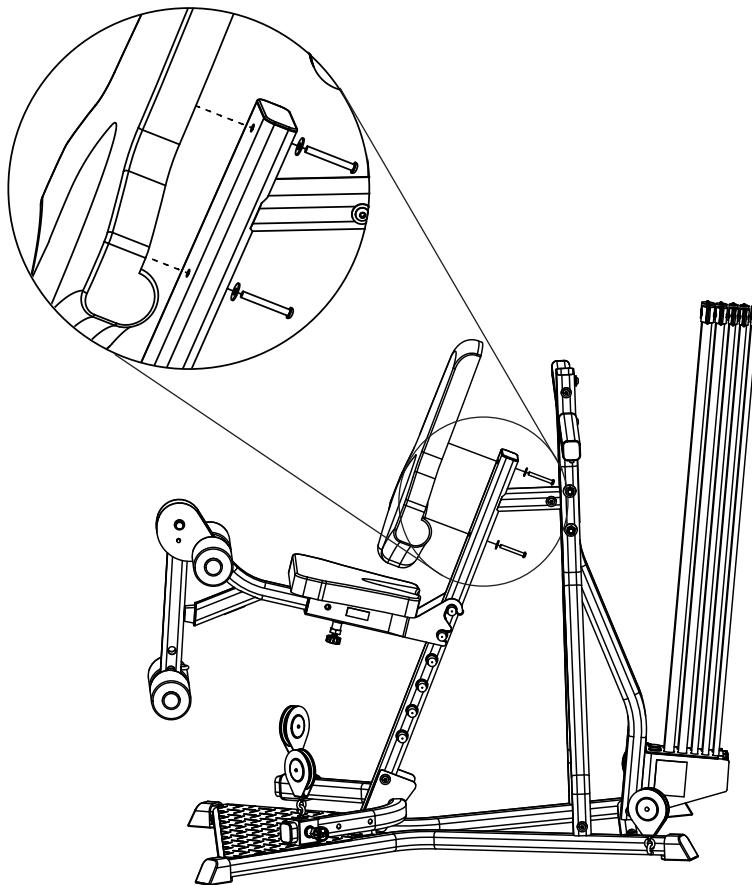
### Parts:

- Seat Back Pad
- Main Assembly

### Hardware:

- 2 Button Head Screws (5/16" X 2 1/2")
- 2 Washers (5/16")

**Tool:** 3/16" Hex Wrench



**13-1** Position Seat Back Pad against the Seat Support Rail and align the screw holes for your height with those on the Seat Support Rail.

**13-2** Secure Seat Back Pad to the Seat Support Rail using screws and washers as shown.

## Step 14 Upper Lat Tower Assembly

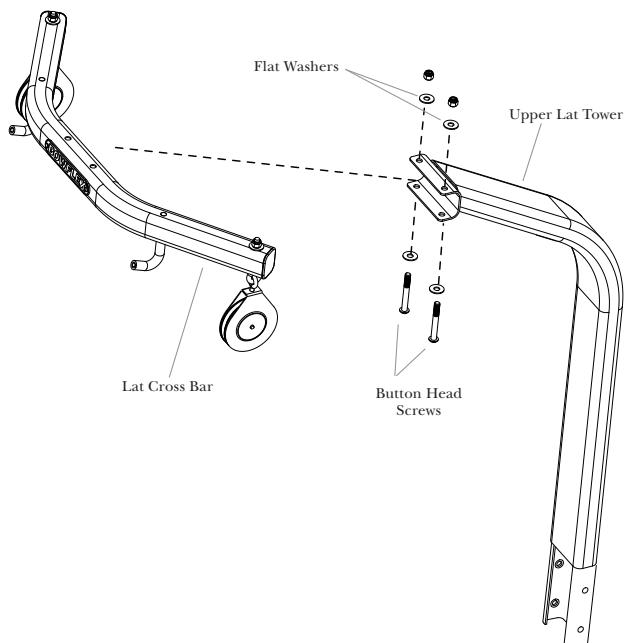
### Parts:

- Upper Lat Tower
- Lat Cross Bar

### Hardware:

- 2 Button Head Screws (3/8" X 3")
- 2 Washers (3/8")
- 2 Nylock Nuts (3/8")

**Tool:** 7/32" Hex Wrench and Adjustable Wrench



**14-1** Align the two holes on the Lat Cross Bar with those on the Upper Lat Tower as shown.

**14-2** Secure using washers and screws as shown.



# Assembly Guide

## Step 15 Ab Bracket Assembly

### Parts:

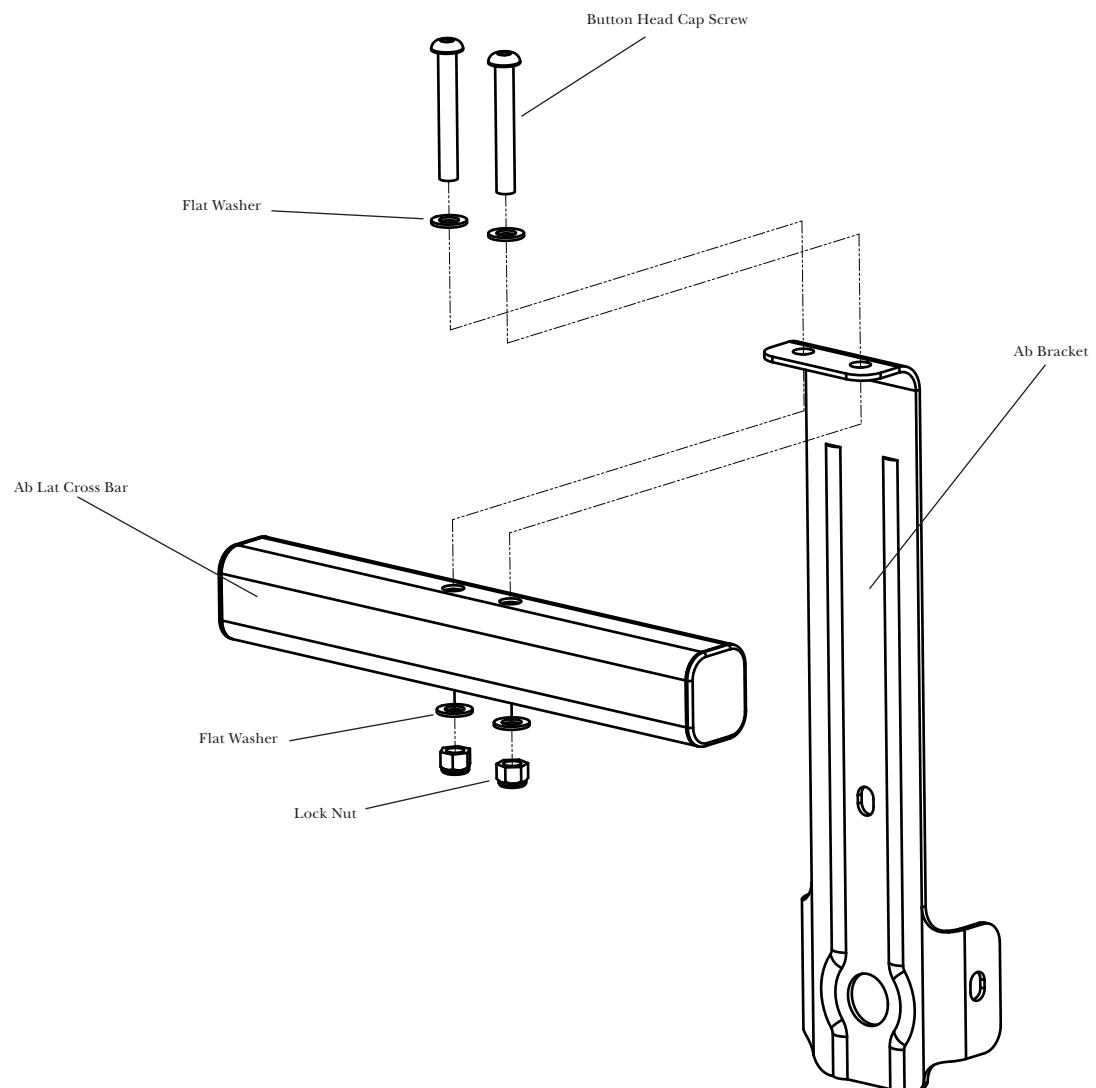
- Abdominal Bracket (2 pieces)

### Hardware (1:1):

- 2 Button Head Screws (3/8" X 2 3/4")
- 4 Washers (3/8")
- 2 Lock Nuts 3/8 -16

**Tool:** 7/32" Hex Wrench

**15-1** Attach the Ab Lat Cross Bar to the Ab Bracket as shown.





# Assembly Guide

## Step 16 Install Upper Lat Tower Assembly and Ab Bracket

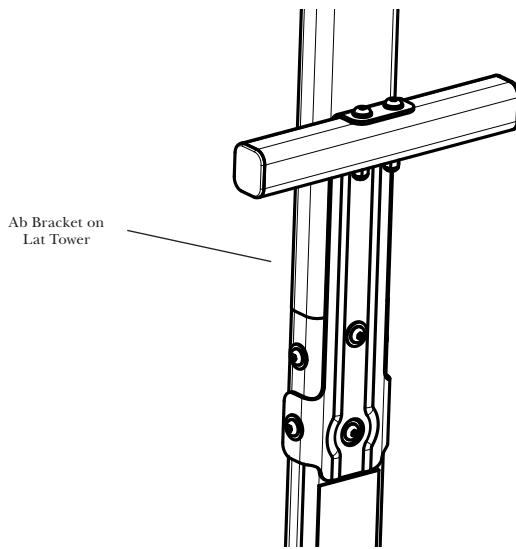
### Parts:

- Upper Lat Tower Assembly
- Abdominal Bracket
- Main Assembly

### Hardware (1:1):

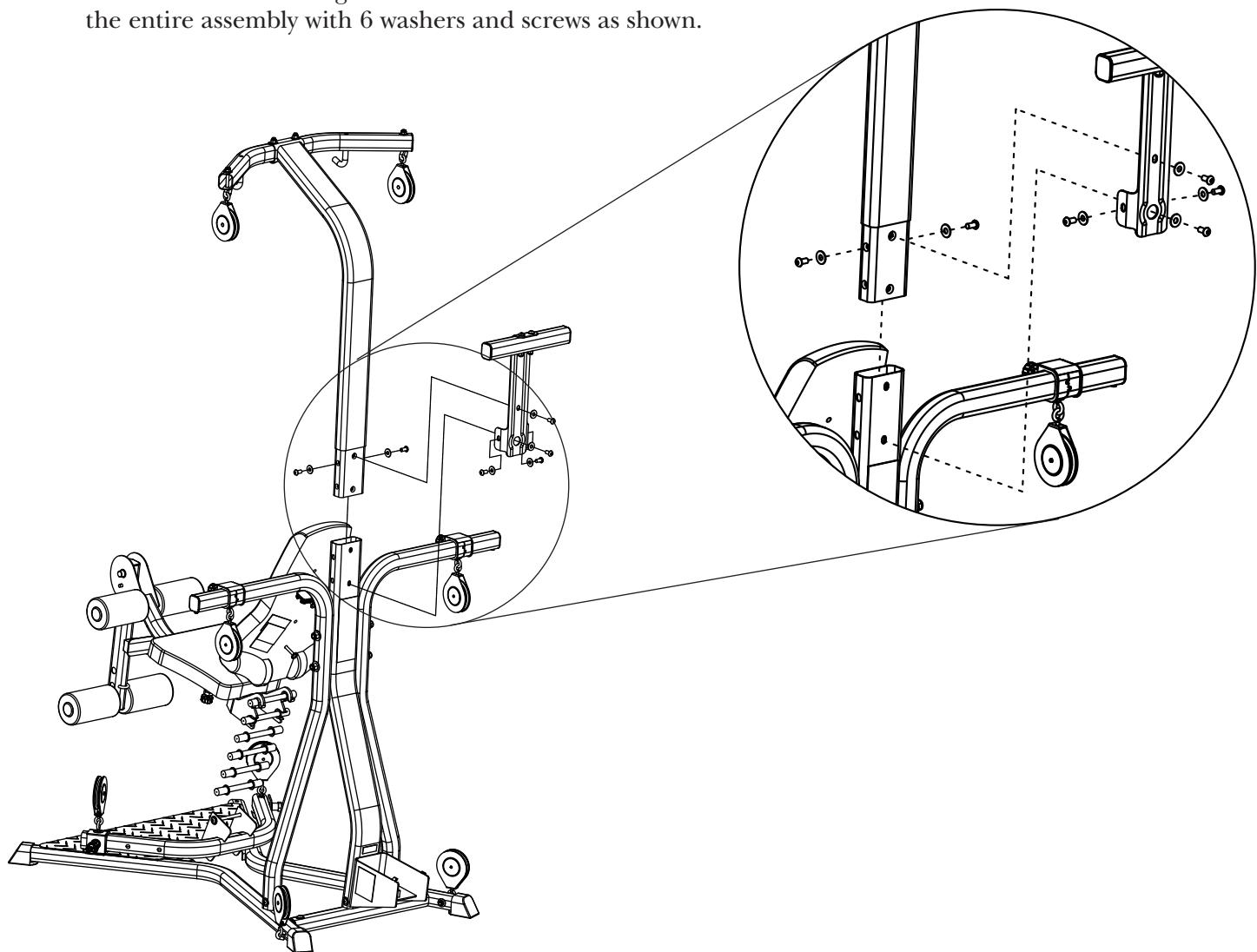
- 6 Button Head Screws (3/8" X 3/4")
- 6 Washers (3/8")

**Tool:** 7/32" Hex Wrench



**16-1** Slide the Upper Lat Tower Assembly onto the Lower Lat Tower.

**16-2** Place the Ab Bracket against the Lat Tower and secure the entire assembly with 6 washers and screws as shown.





# Assembly Guide

## Step 17 Tighten Hardware

**17-1** Carefully go over the entire Bowflex Xtreme® SE home gym and tighten all hardware before proceeding to the next step. Pay close attention to the hardware installed in Steps 1, 3, 4, and 6.

## Step 18 Connecting Cables

**Parts:** Completed Bowflex Xtreme® SE home gym

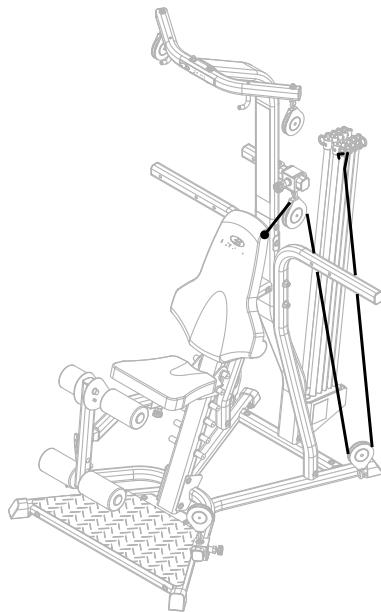
**Tool:** Scissors or other cutting tool (not included)

**18-1** Remove the wrapping from around the coiled cable and pulley attached to the Right and Left Frame Rails.

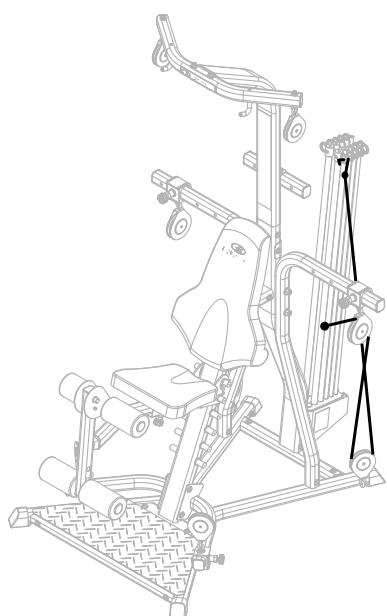
**18-2** Remove the wrapping from around the coiled cable and pulley attached to the left and right side of the lat tower.

**18-3** Attach the cable to the home gym following the routing for the various exercise positions.

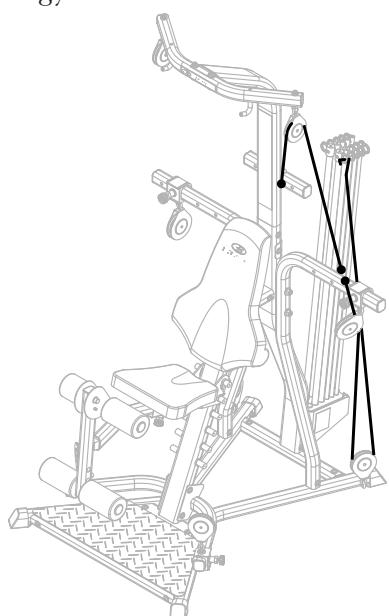
**NOTE:** As you use your home gym, you will connect the cables and pulleys in a variety of ways to perform the exercises. Refer to the Owner's Manual for information on using the Bowflex Xtreme® SE home gym..



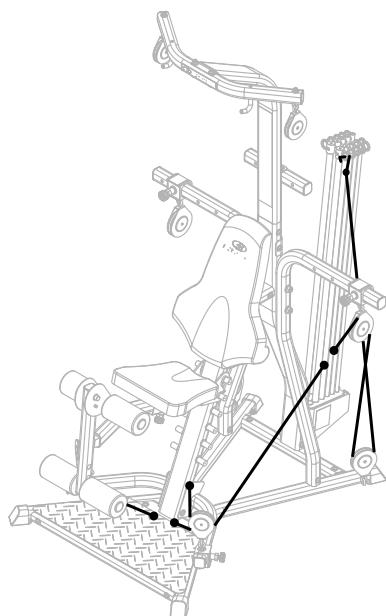
**Abdominal Exercises**



**Chest Exercises**



**Lat Pulldown Exercises**



**Leg and Squat Exercises**



## Assembly Guide

### Step 19 CONGRATULATIONS!

You have successfully completed assembly of your Bowflex Xtreme® SE home gym! Please inspect your machine to ensure that all fasteners are tight and components are properly assembled. Review all warnings affixed to machine.



#### WARNING

**Failure to visually check and test assembly before use can cause damage to the Bowflex Xtreme® SE home gym and serious injury to users and bystanders and can also compromise the effectiveness of your exercise program.**



## Important Contact Numbers

If you need assistance, please have both the serial number of your machine and the date of purchase available when you contact the appropriate Nautilus office listed below.

### **OFFICES IN THE UNITED STATES:**

E-mail: [customerservice@nautilus.com](mailto:customerservice@nautilus.com)

- NAUTILUS INNOVATION CENTER  
Nautilus, Inc.  
1886 Prairie Way  
Louisville, Colorado, USA 80027  
Vancouver, Washington, USA 98683  
Phone: 800-NAUTILUS (800-628-8458)  
Email: [customerservice@nautilus.com](mailto:customerservice@nautilus.com)  
Fax: 800-898-9410
- TECHNICAL/CUSTOMER SERVICE  
Nautilus, Inc.  
World Headquarters  
16400 SE Nautilus Drive  
Vancouver, Washington, USA 98683  
Phone: 800-NAUTILUS (800-628-8458)  
Email: [customerservice@nautilus.com](mailto:customerservice@nautilus.com)  
Fax: 877-686-6466
- CORPORATE HEADQUARTERS  
Nautilus, Inc.  
World Headquarters  
16400 SE Nautilus Drive  
Vancouver, Washington, USA 98683  
Phone: 800-NAUTILUS (800-628-8458)

### **INTERNATIONAL OFFICES:**

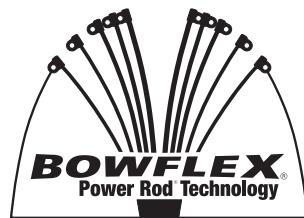
For technical assistance and a list of distributors in your area, please call or fax one of the following numbers.

- INTERNATIONAL CUSTOMER SERVICE  
Nautilus International S.A.  
Rue Jean Prouvé 6  
1762 Givisiez / Switzerland  
Tel: + 41-26-460-77-77  
Fax: + 41-26-460-77-70  
Email: [technics@nautilus.com](mailto:technics@nautilus.com)

### **BUSINESS OFFICES:**

- SWITZERLAND OFFICE  
Nautilus Switzerland S.A.  
Tel: + 41-26-460-77-66  
Fax: + 41-26-460-77-60
- GERMANY and AUSTRIA OFFICE  
Nautilus GmbH  
Tel: +49-2204-610-27  
Fax: +49-2204-628-90
- ITALY OFFICE  
Nautilus Italy s.r.l.  
Tel: +39-051-664-6201  
Fax: +39-051-664-7461
- UNITED KINGDOM OFFICE  
Nautilus UK Ltd.  
Tel: +44-1908-267-345  
Fax: +44-1908-267-346
- CHINA OFFICE  
Nautilus Representative Office  
Tel: +86-21-523-707-00  
Fax: +86-21-523-707-09





## **BOWFLEX** **XTREME SE**

© 2006 Nautilus, Inc. All Rights Reserved.

Nautilus, Inc. World Headquarters, 16400 S.E. Nautilus Drive, Vancouver, Washington USA 98683 1-800-NAUTILUS (1-800-628-8458)  
Bowflex, Bowflex Xtreme, Power Rod and the Bowflex logo are either registered trademarks or trademarks of Nautilus, Inc. All other trademarks are trademarks of their respective companies.

Printed in China